

Work Order ID 60646

Thursday, July 15, 2010 11:34:26 AM



Page 1

Item ID: D3947-2

Accept



Setup Start



Revision ID:

Item Name: Panel, Upper RH Post

Stop



Start Date: 7/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

H

Date: 10-7-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3947

A

100

0.00



HAND FINISHING THERMOFORMING

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut Blanks to fit frame size

(X1) BB

10/07/19

105

0.00



Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp:

240 F°

Time IN:

4:30 PM 10/07/18

Time OUT:

7:00 AM 10/07/19

(X1) BB

10/07/19

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:			WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 60646

Thursday, July 15, 2010 11:34:26 AM



Page 3

Item ID:	D3947-2	Accept		Setup	Start	
Revision ID:				Stop		
Item Name:	Panel, Upper RH Post					
Start Date:	7/15/2010	Start Qty:	1.00			
Required Date:	7/22/2010	Req'd Qty:	1.00			
Reference:				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions as per dwg D3946-1	0.00 0.00							BB 10/07/21
150 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Check dimensions to ensure conformity to drawing tolerances.	0.00 0.00							BB 10/07/21
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							S 10/07/21

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60646

Thursday, July 15, 2010 11:34:26 AM



Page 4

Item ID:	D3947-2	Accept		Setup	Start	
Revision ID:						
Item Name:	Panel, Upper RH Post				Stop	
Start Date:	7/15/2010	Start Qty: 1.00				
Required Date:	7/22/2010	Req'd Qty: 1.00				
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	Identify as per dwg & Stock Location: <u>150</u>	0.00							
Packaging									
Packaging	Memo	0.00							
180 	QC21- Final Inspection - Work Order Release	0.00							
QC									
Quality Control	Memo	0.00							

10/7/27

SP

10/07/28

H10-7-27
①

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 15, 2010 11:34:30 AM

Page 1

Work Order ID: 60646

Parent Item: D3947-2

Parent Item Name: Panel, Upper RH Post

Start Date: 7/15/2010


Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

IPP RevB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,876.541	3.3055	3.479474			
													

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

therm

1876.541

107574

13.72

111973

30.875

112176

101.2267

114459

1730.7193

(X) BB

10/02/19

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	40046
Description: Panel, Upper RH		Part Number:	D3947-2
Inspection Dwg: D3947	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching				

Measured by: BB

Date: 10/07/21

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.0	Min	10.25	✓			
0.2	Min	.304	✓			
0.5	Min	.542	✓			
1.8	Min	1.836	✓			
3.1	REF	3.5	✓			
26.6	REF	26.675	✓			
0.050	Min	.083	✓			
0.070	Min	.073	✓			

Measured by: BB

Date: 10/07/21

Audited by: BB

Date: 10.07.21

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	BB

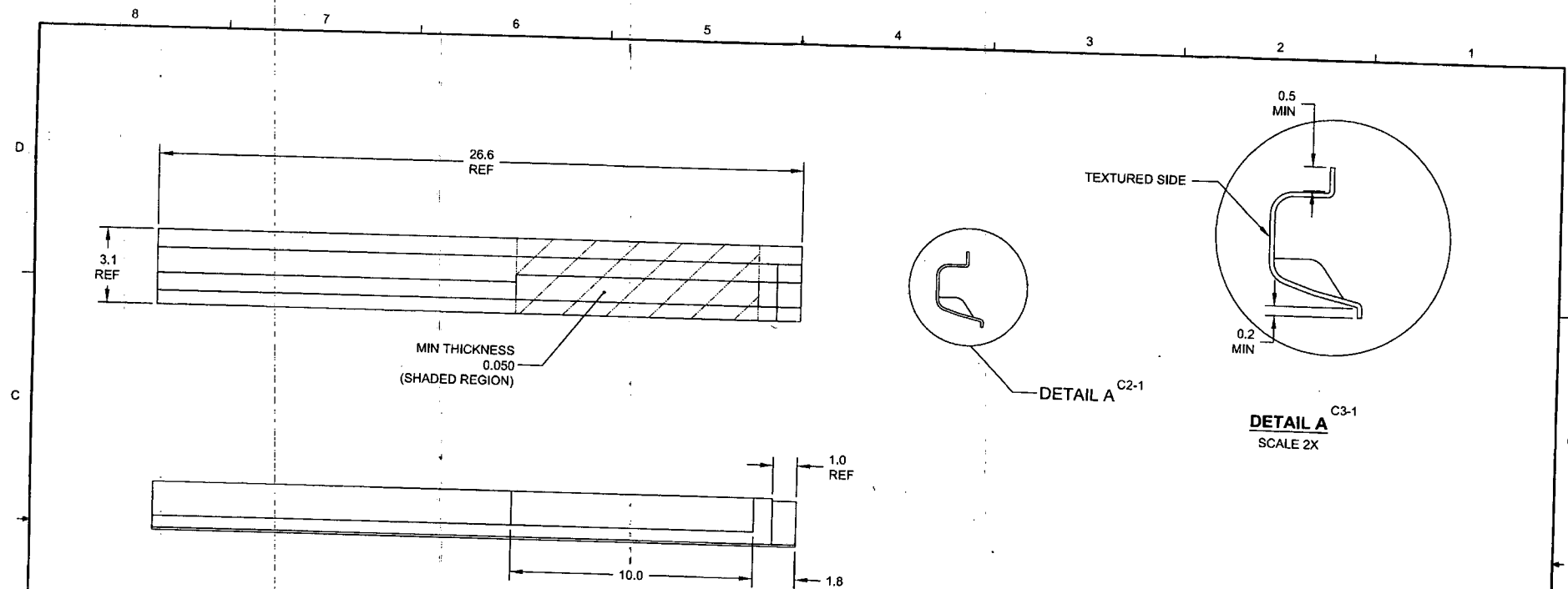
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3947-1 PANEL, LH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *W00444*
P10-715

RELEASED
04/06/14 MJD

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY58133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-1" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.42 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9483 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.070" ELSEWHERE

A	NEW ISSUE	PH	09.05.20
REV.		BY	DATE
DESIGN		DESCRIPTION	
DRAWN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	D3947	SHEET 1 OF 4
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	PANEL (AS 350/355)	NTS
DATE	09.05.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

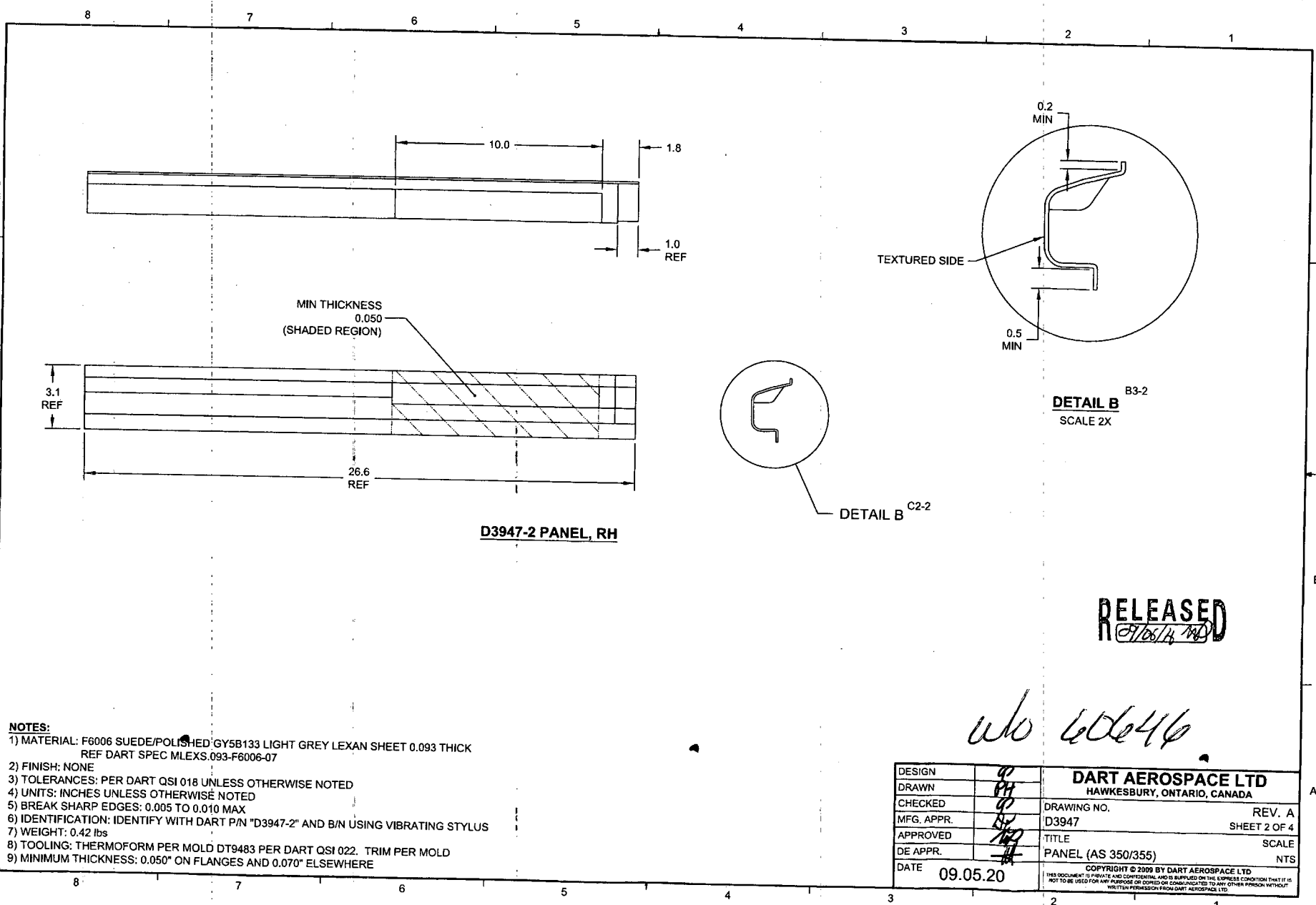
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- NOTES:**
- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-2" AND B/N USING VIBRATING STYLUS
 - 7) WEIGHT: 0.42 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9483 PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.070" ELSEWHERE

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3947	SHEET 2 OF 4
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DE APPR.	PH	PANEL (AS 350/355)	NTS
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RELEASED
07/05/14 MD

WLO 60646

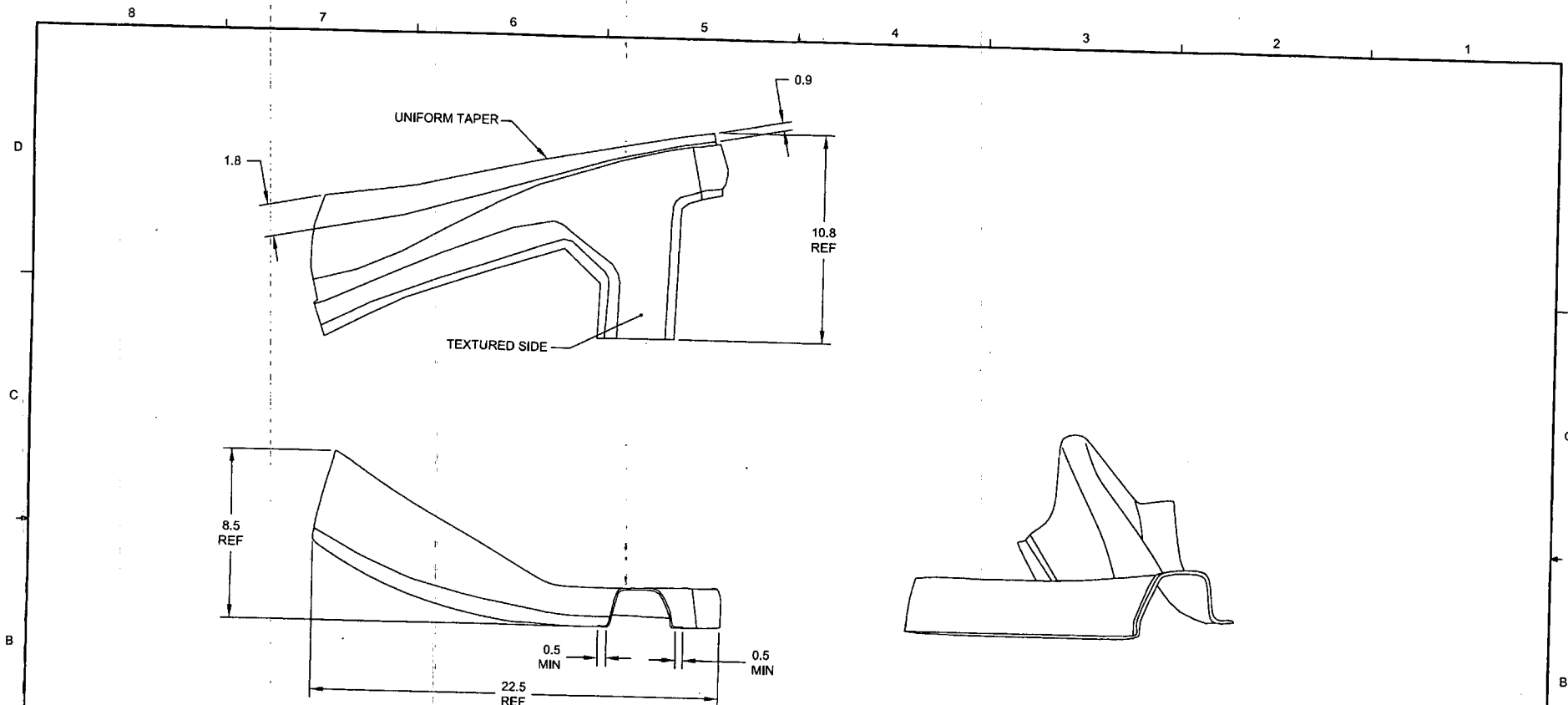
W/O:			WORK ORDER CHANGES					
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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3947-3 PANEL, LH

RELEASED
09/06/14

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS:093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-3" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.55 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9484 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3947	SHEET 3 OF 4
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DE APPR.	PH	PANEL (AS 350/355)	NTS
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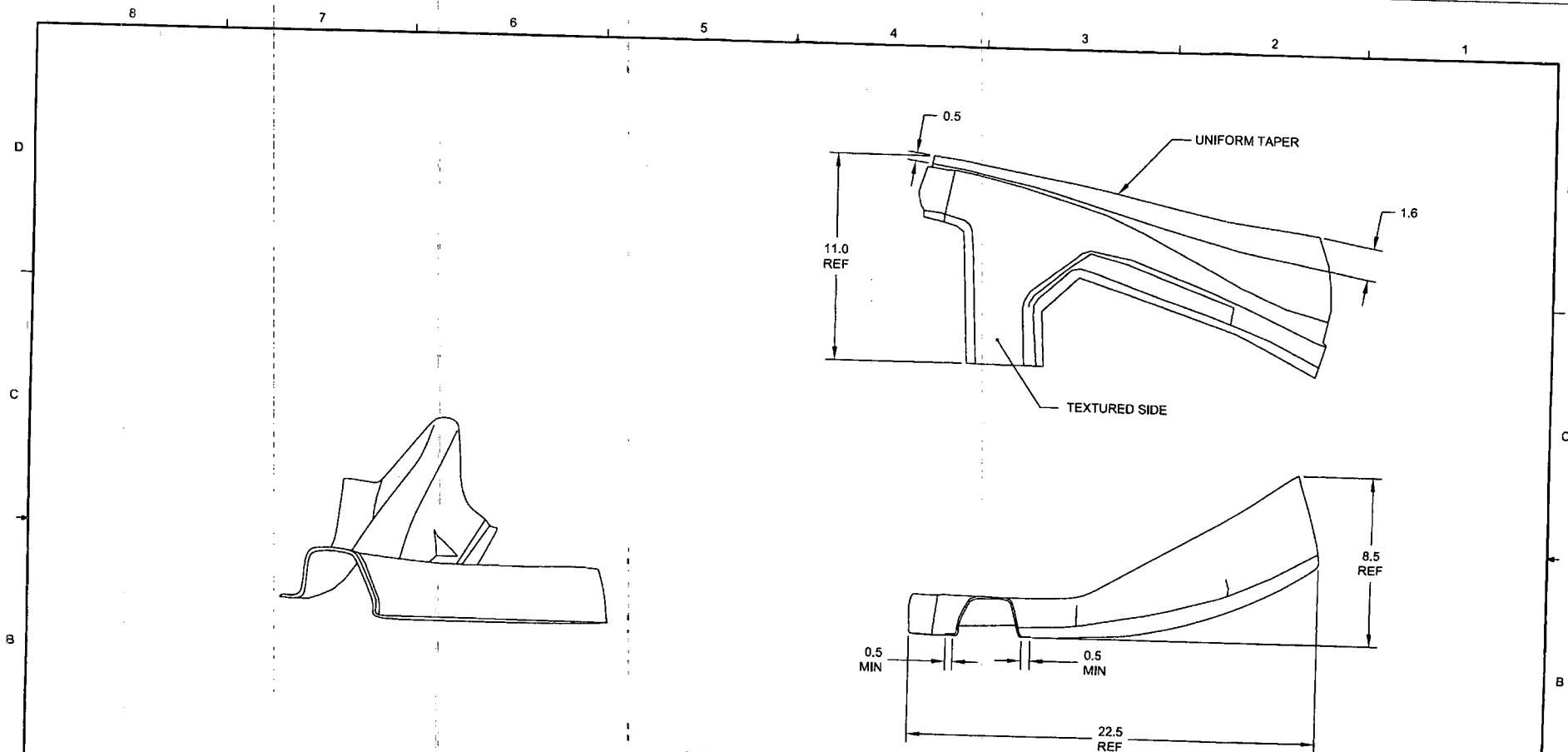
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3947-4 PANEL, RH

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-4" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.62 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9484 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE

RELEASED
09/05/20

DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	90	DRAWING NO.	REV. A
MFG. APPR.	90	D3947	SHEET 4 OF 4
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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries